







2-sided WoodInserts L50

A09-900

The cycle time for a 2-sided reversible knife includes handling - loading and rotating - as well as the grinding of the 2 sides. To keep the time low grinding and handling operations have been optimized to a minimum of movements and the usage of one single wheel, which allows to grind the 45° clearance in one pass.



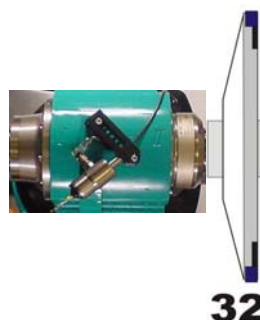
1. Cycletime for Production

Tool specifications from rectangular blank 50x14 Material CARBIDE				
Operations	 1st side	 Rotate tool	 2nd side	 Loading
Feed [mm/Min]	500	2000	500	2000
Power [kW]	1		1	
Cutting feed [m/s]	34		34	
Used wheels	 32		 32	
Grinding time [s]	15	9	15	9
Total cycle time	0 Min 47			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

32 Ø250 12C9 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM, STL 650
 Control: Fanuc 160i
 Coolant: Synthetic Oil, pressure 6 - 7 bar
 Software: Quinto 4.3

responsible engineer: KOC, 122.8.08

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, UK, China